

Work Order ID 76181

76181

Page 1

November-07-11 1:24:02 PM

Item ID: D3041-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 07/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 26/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3041	Rev C

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut D2423 Extrusion: 1.250" Long

cut @ meter

CZ 11/11/11

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Check for cracks while loading into the machine
 Machine as per Folio FA153 and Dwg D3041
 DWG REV: _____
 FOLIO REV: _____

Issue Proto meter

CZ 11/11/11 (12)

120 *rec'd* 0.00
120 QC Memo 0.00
 Quality Control

*rec'd + inspect for transit damage
 attached C of C to W/O*

11/11/23 (12)

machine as per dwg D3041 REV.C P/O: 15437

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC Inspect parts - second check Memo	0.00 0.00							<u>712</u>
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							<u>12 BR 11-11-08</u>
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Mask inside of 0.8120" diameter hole START TIME: 9:45 OVEN TEMPERATURE: 320°F FINISH TIME: 9:45	0.00 0.00							<u>12x of m-f 11/11/09</u>

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 07/11/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 12.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12 BL 11-11-29

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

1- Press D2611 bearing into lug as per Dwg D3041 using DT 9472

2- Stake bearing into place as per Dwg D3041 using DT9456

3-Touch up stake marks with white emeron paint

11/11/30 (12)

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

11/11/30 (12)

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: SJ 462	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

(12x) - **SP 11-12-01**

11/12/11

mf 11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-07-11 1:24:06 PM

Page 1
1

Work Order ID: 76181

76181

Parent Item: D3041-3

D3041-3

Parent Item Name: Clamp

Start Date: 07/11/2011

Required Date: 26/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A01.07.11New IssueSM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611 *D2611* Bearing		Manufactured	No			100	Each	30.0000	1	12	**	07/11/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST018		30							
				68916		30			12				
D2423 *D2423* Lug Extrusion		Manufactured	No			170	f	463.1400	0.1042	1.316211	**	07/11/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		463.14							
				43722		161.5							
				45800		1							
				68331		300.64			1.32				

D3041-3 P

07/11/23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

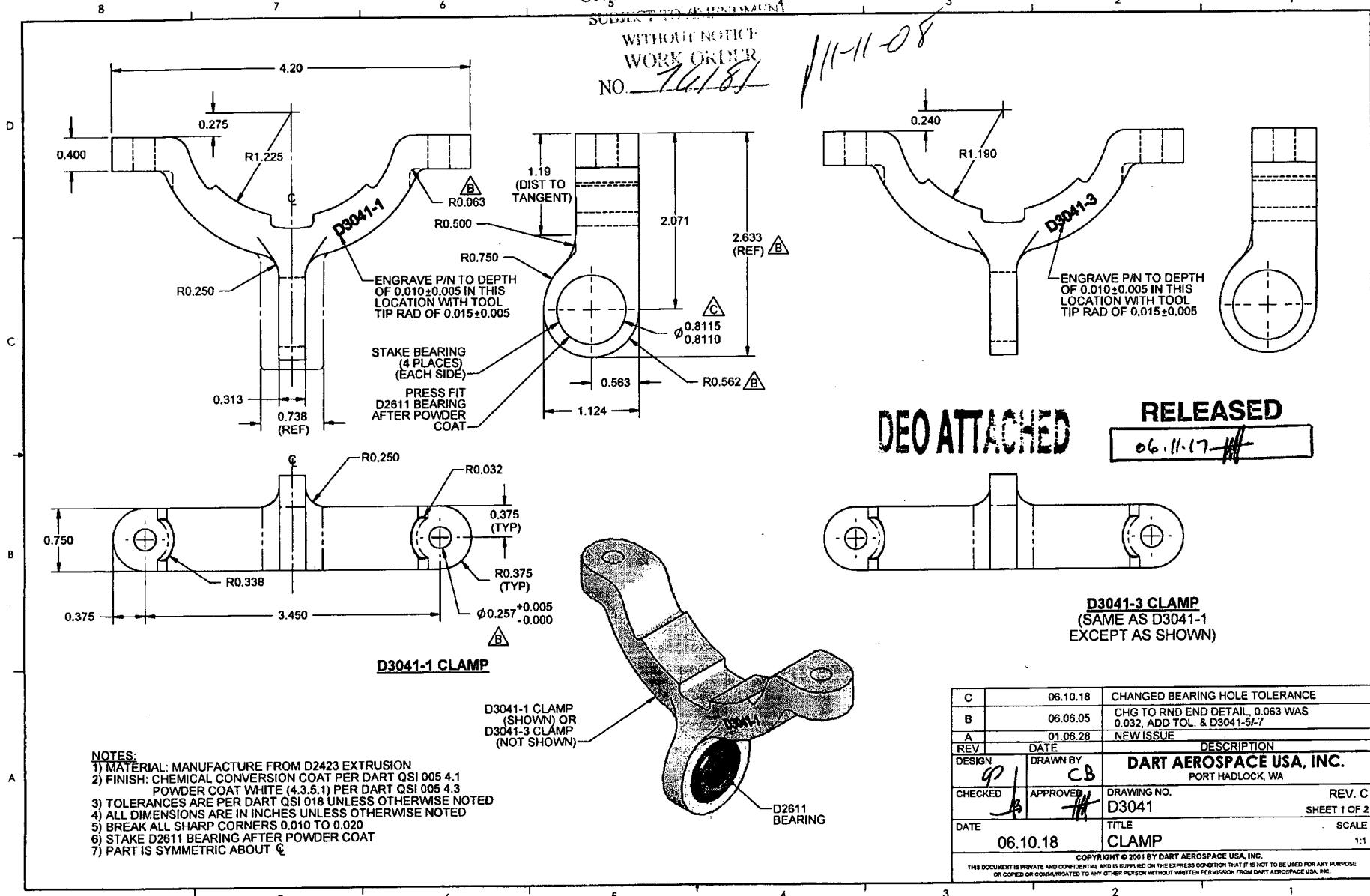
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

WITHOUT NOTICE
WORK ORDER
NO. 76181

11-11-08



DEO ATTACHED

RELEASED

06.11.17

D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)

D3041-1 CLAMP

D3041-1 CLAMP
(SHOWN) OR
D3041-3 CLAMP
(NOT SHOWN)

D2611
BEARING

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

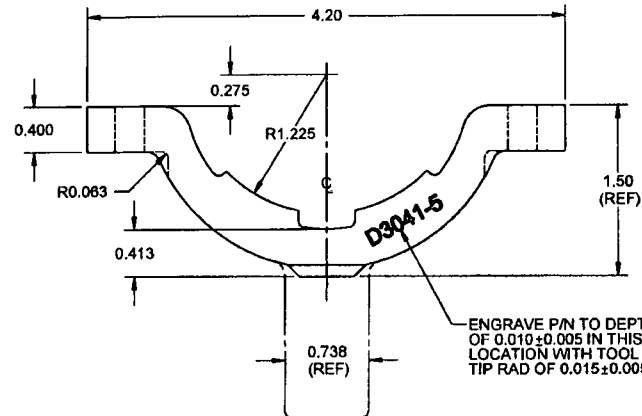
C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5I-7
A	01.08.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. D3041
		TITLE CLAMP
		REV. C SHEET 1 OF 2
		SCALE 1:1

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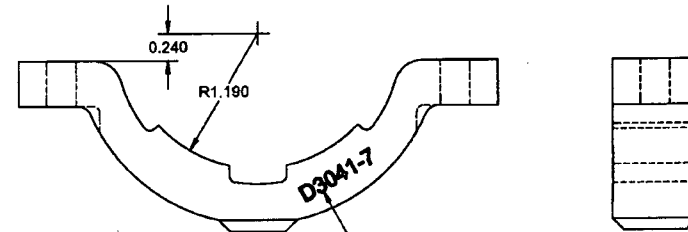
DEO ATTACHE

RELEASED

06.11.17

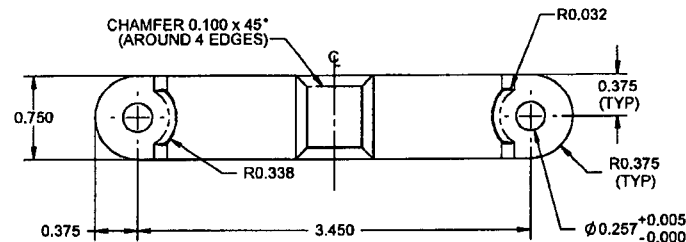


ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005

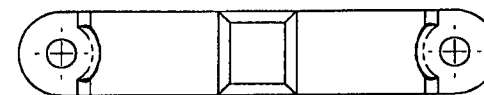


ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005

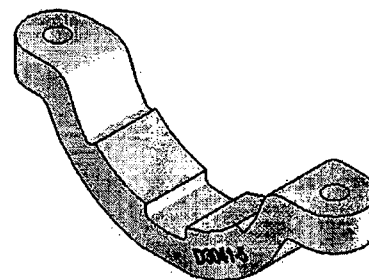
76181



D3041-5 CLAMP



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

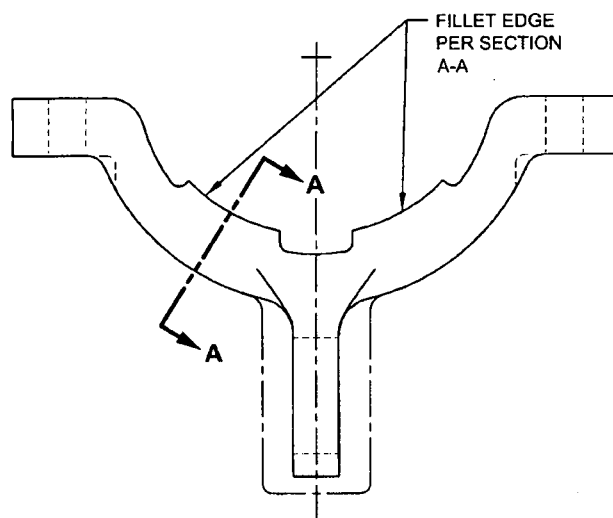


- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) PART IS SYMMETRIC ABOUT ϕ

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA	
DATE	TITLE	DRAWING NO.	REV. C
06.10.18	CLAMP	D3041	SHEET 2 OF 2
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.		SCALE	
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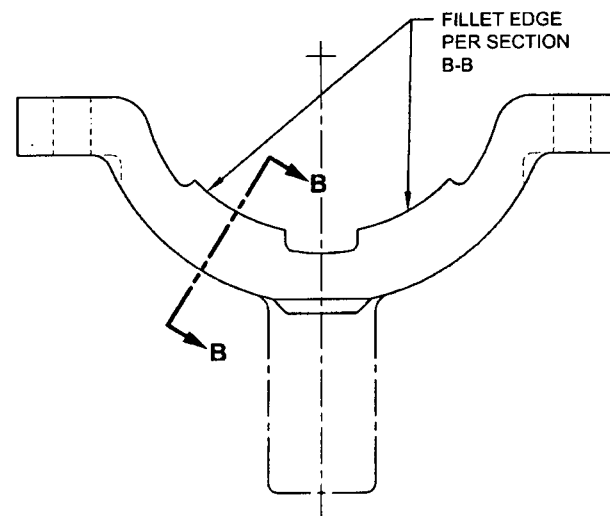
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 155	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15437

Purchase Order Date 11/11/11

PO Print Date 11/14/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED
\$

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3041-3P	CLAMP	11/16/11 Yes	12.00 Each	Dart Truck	\$42.0000	\$504.00

Special Inst: MACHINE AS PER DWG D3041 REV. C
B76181

PO Total:

\$504.00

Change Nbr: 2

Change Date: 11/14/11

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

Date:

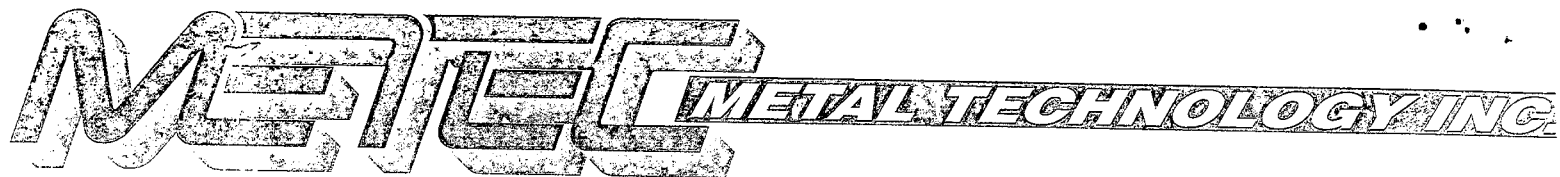
Nov 22, 2011

Page:

1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO15437	Sold By: Dewar, Eric
Shipped By:	Ship Date: Nov 23, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-3P Clamp Machine as per DWG D3041 REV.C B76181	Each	12	12	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
12	D3041-3P	Mounting Lug	15437

MATERIAL: supplied by DART D3041 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in dark ink, appearing to read "Jan Norris".

Jan Norris

Vankleek Hill, November 23 2011